

Dn 20 – Dn 63 FITTINGS ASSEMBLING INSTRUCTIONS

EQOair – EQOh2o – EQOnitro – EQOfire – EQOvac – EQOairHP – EQOoil/HP – EQOnitroHP

1. Needed tools and materials

1.1. Tools for pipe cutting :

(Mitre saw – band saw – hand saw)



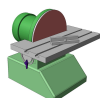
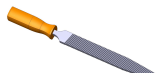
1.2 Tool for the internal deburring of the pipe :

(Blade deburring tool)



1.3 Tool for external deburring of the pipe :

(Deburring tool – flat file – disk sander)



1.4 Lubricant :

(Vaseline grease – soapy water – oil (in case of EQOoil fittings))

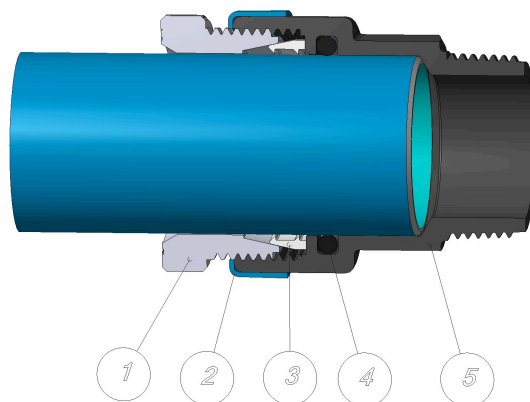


1.2. Marker :

(indelible pen or paint based marker)



2. Assembly with correct components positioning



1. Nut
2. Identification ring
3. Clamping ring
4. O-ring gasket
5. Fitting body.

2. Preparation

3.1 Verify the integrity of the pipe section to be inserted in the fitting.

Any scratches on the paint, if not deep, can be eliminated using 300÷600 fine emery paper. Deep dents or scratches can be eliminated only by changing the branch position or by replacing the pipe section interested.

3.2. Verify the correct positioning of the components inside the pipe.

Fittings are supplied assembled and they have not to be disassembled. In case of accidental disassembly, check the correct assembly sequence and the position of all components which has to be the one of the ensemble figure at point 2 only. As the case may be :

- a. loosen the nut while pulling the identification ring outwards until the lower side of the inspection slot lines up with the fitting end surface.
- b. screw the nut, without tightening, up to observe a light resistance

3.3. If necessary, cut the pipe with a neat 90° cut, after carefully deburring both the internal and external sharp resulting edges.

In any case, the pipe bars used in the original supply length are to be deburred internally and externally.

3.4. Mark the pipe so to have a reference for its correct insertion into the fitting to make sure it exceeds the gasket.

The following table shows the correct reference lengths (in parenthesis, branch ones)

Dn	20	25	32	40	50	63
L(mm)	35 (31)	37 (35)	46	56	68	83

3.5 Lubricate the marked pipe section.

Use soapy water or any other lubricant compatible with the transported fluid.

In case of doubt, please contact our technical service : giacomo@eqofluids.com.

Dn 20 – Dn 63 FITTINGS ASSEMBLING INSTRUCTIONSEQO**air** - EQO**h2o** - EQO**nitro** - EQO**fire** - EQO**vac** - EQO**airHP** - EQO**oil/HP** - EQO**nitroHP**

1

2

3

4. Assembling

4.1. Deeply insert the pipe into the fitting up to align the reference mark with the external nut surface, as showed in fig.2.

4.2. Tighten the nut.

Tightening have to be done by hand; in this case both water tightness and axial clamping are ensured.

Spanner tightening limits possible light linear expansions due to settlements.

In case you want to tight with a tools with torque value please follow the below values:

Diameter	Torque Value	Description
D20	2,5 N - m	Nut
D25	3,0 N - m	Nut
D32	3,5 N - m	Nut
D40	4,0 N - m	Nut
D50	6,0 N - m	Nut
D63	8,0 N - m	Nut
D90	10,0 N - m	Nut
D110 - D160	18,0 N - m	Bolt

The up mentioned value are similar to the value used tightening by hands till the starting of rotation of the pipe.

In any case, after the initial pressure raising, it is advisable to check and tighten all the nuts of the installation

Warnings and recommendations

Assembling instructions contain images only referring to the **EQOair** line, but they refer to all

EQOf fluids® products, but keeping in mind the following details :

- When using high pressure fittings (PN70) it is always advisable to tighten nuts by a spanner so to limit longer linear expansions due to natural settlements consequent to the higher specific load.
- During the testing the applied pressure has to be at least 1,5 the value of the maximum service pressure in conditions of absolute safety for the staff and the equipments connected. Said equipments, having, in case, lower pressures than the pipes testing one, (for instance, safety valves, pneumatic tools, etc.) have to be duly isolated or disconnected from the installation.
- After testing or after first putting under pressure, it is advisable to check and tighten all fitting nuts.
- If using a lubricant to help the pipe insertion, its compatibility with the transported fluid is to be carefully checked.

More technical information can be found on our website: www.eqofluids.com